

Date: Tuesday, 3/4/2008 11:29:44 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : I-BEAM EXTRUSION
 Job Number : 37669
 Estimate Number : 10045
 P.O. Number :
 This Issue : 3/4/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : LANDING GEAR
 Previous Run :
 Written By : W
 Checked & Approved By : W
 Comment : Est. A: 01.04.19 New Issue EC

Part Number : D6202
 Drawing Number : D6202 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 3/11/2008 Qty: 30 FT Um: F

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 588608/03/12 55 FT

a) Description: American standard I-beam 4.000" x 2.796" x 0.326" thick

b) Material: 6061-T6/T651 (QQ-A-200/8)

c) Minimum ultimate tensile strenght = 38 ksi

d) Minimum yield tensile strenght = 35 ksi

2.0

D6202P

I Beam Extrusion



Comment: Qty.: 1.0000 f(s)/Unit Total : 40.0000 f(s)

I Beam Extrusion

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

08/03/0850' P/M

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6202

08/03/08 50'

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: OSB 8-3-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/4/2008 11:29:44 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: I-BEAM EXTRUSION

Job Number: 37669

Part Number: D6202

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08 04.03
[Signature]

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-03-31

u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

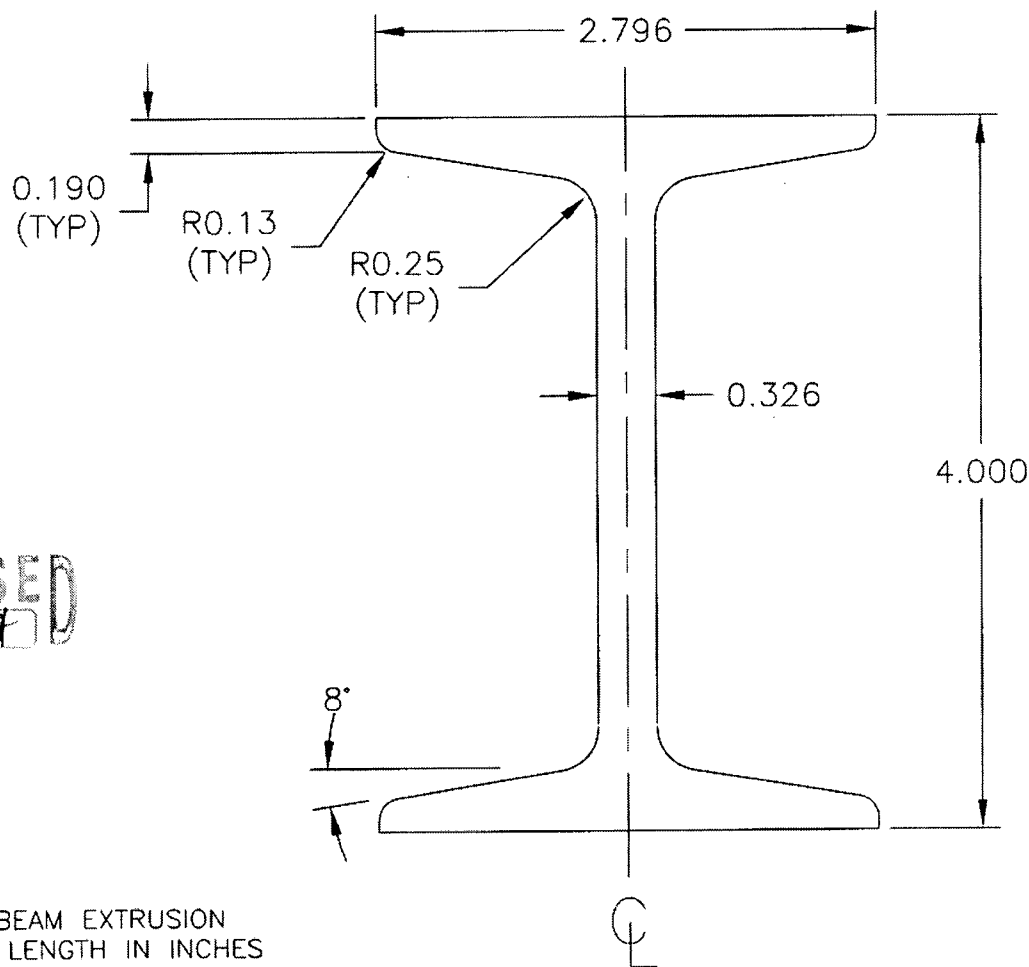
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6202	REV. A SHEET 1 OF 1
DATE 01.04.02		TITLE I-BEAM EXTRUSION	SCALE 1:1
A	01.04.02	NEW ISSUE	

SPECIFICATION CONTROL DRAWING



D6202-XXX I-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6202-027 IS 27 INCHES LONG

PURCHASE MATERIAL: AMERICAN STD. I-BEAM
4.000" x 2.796" x 0.326" THICK
6061-T6/T651 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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C208/03/04
W10: 37669

CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS



SERVICE CENTER METALS
5850 Quality Way
Prince George, VA 23875

OUR ORDER NUMBER	ITEM
716817	26

BILL TO YAMMEX METALS SHIP TO YAMMEX METALS	MANIFEST NUMBER 54376	DIE NUMBER BS0291	DATE OF SHIPMENT 1/23/2008	CERTIFICATION ASTM-B308 Stencil
	CUSTOMER PO P71107CG008 CT	ALLOY / TEMPER 6061-T6	SALESPERSON David Schroeder	SPECIFICATION ASTM-B221-06
	CUSTOMER PART NUMBER BS0291	DESCRIPTION ASI 4.000x2.786x.326		SPECIFICATION AMS-QQA-200/8
				SPECIFICATION AMS-QQA-200/16

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown. SCM extrusions are manufactured in the USA from ingot melted and cast in the United States or Canada.

Mechanical Properties

Lot No.	Test No.	Test Date	Ultimate Tensile Strength (KSI)	Yield Strength (KSI)	Percent Elongation
200801288	1	01/17/08	45.7	40.8	16.4

SCM METALS, INC. CERTIFIES THAT
THIS IS A TRUE COPY OF THE ORIGINAL
TEST REPORT NOW ON FILE
AND REVIEWED AND INSPECTED

24 2008

David Schroeder
CERTIFICATION PROCESSOR

Chemical Composition for Alloy 6061

Alloy		Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Other	Each	Total	Al	Melted In
6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15		Remainder	United States of America
	Min	0.40	-	0.15	-	0.8	0.04	-	-	-	-			

Rev. 9/25/07 - LWS

Print Date: 1/23/2008

Robert M. Ramage
Robert M. Ramage Ph.D, Director of Quality & Technical Services

CF 401



SERVICE CENTER METALS
5850 Quality Way
Prince George, VA 23875

CERTIFIED INSPECTION REPORT AND TEST RESULTS FOR EXTRUDED PRODUCTS

OUR ORDER NUMBER	ITEM
717073	1

BILL TO	MANIFEST NUMBER	DIE NUMBER	DATE OF SHIPMENT
	53696	BS0291	1/11/2008
SHIP TO	CUSTOMER PO	ALLOY / TEMPER	SALESPERSON
	P71217DS004 CT	6061-T6	David Schroeder
	CUSTOMER PART NUMBER	DESCRIPTION	
	BS0291	ASI 4.000x2.796x.326	

CERTIFICATION
ASTM-B308 Stencil
SPECIFICATION
ASTM-B221-06
SPECIFICATION
AMS-QQA-200/8
SPECIFICATION
AMS-QQA-200/16

We hereby certify that the material covered by this report has been inspected in accordance with the most recent certification revision, and has been found to meet the applicable requirements described herein, including any specifications forming a part of the description, and that samples representative of the material met the composition limits and had the mechanical properties shown. SCM extrusions are manufactured in the USA from ingot-melted and cast in the United States or Canada.

Mechanical Properties

Lot No.	Test No.	Test Date	Ultimate Tensile Strength (KSI)	Yield Strength (KSI)	Percent Elongation
200801037	1	01/08/08	46.2	44.1	14.1

Chemical Composition for Alloy 6061

Alloy		Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Other	Each	Total	Al	Melted In
6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15		0.05	0.15	Remainder	United States of America
	Min	0.40	-	0.15	-	0.8	0.04	-	-					

Rev. 9/06/07 - LMS

Print Date: 1/11/2008


Robert M. Ramage Ph.D, Director of Quality & Technical Services